

Work Order ID 86729

July-06-12 11:46:07 AM

86729

Page 1

Item ID: D2199-23 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Details
 Start Date: 7/06/12 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: ✓ Date: 12-07-9 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2199	Rev E1								
100		0.00							SB 12/07/17
100	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Punch per Dwg D2199 and Spec Control Dwg D2638								
110		0.00							
110	Small Fab								Ae 12-07-18
Small Fab	Memo	0.00							12-08-01
Small Fab	Deburr								
120		0.00							
120	QC5- Inspect part completeness to step on W/O								Pro →
QC	Memo	0.00							
Quality Control									

SCRAP

W/O: 86729		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: P2198-23 PAR #: _____ Fault Category: Small Fab NCR: Yes No DQA: for Date: 12/08/13
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: AD Date: 12/08/14

NCR: 12-1654		WORK ORDER NON-CONFORMANCE (NCR) $39.02 \times 2 = 78.04$						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/08/01	#1 110	Found at inspection that the 0.316" hole was not drilled. when part was sent back to be drilled as per drawing set was returned to be drilled the hole was drilled over size measure 0.325"	U 12/08/01	-Scrap + destr dth + 2 struts - cut off ends and mark original Material Batch #s	ke 12.08.01	DAS 16 2-83 12/08/01	U 12.08.01	DAS 16 2-83 12/08/01
		Per drawing set was returned to be drilled the hole was drilled over size measure 0.325"		be use on other strut				DAS 16 2-83 12/08/01
		Drill bit before drilled hole. complete lack of ability in employees fault.						

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									

MS 12/08/01

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

July-06-12 11:46:07 AM

Item ID: D2199-23

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut Details

Start Date: 7/06/12 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 7/06/12 **Req'd Qty:** 2.00 ***2***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

July-06-12 11:46:07 AM

Page 1

Work Order ID: 86729

Parent Item: D2199-23

Parent Item Name: Strut Details

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: D02.06.10Rem polish & add finishNG/CC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 304 RD Tube .750 x .049W		Purchased	No			100	f	686.9558	2.2	4.631579		DN 12/07/12	

Location

Loc Qty

Loc Code

MAT017

686.955794

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

116108

3

117797

0.75

120441

0.000794

121170

234.89

121666

18.232

122312

400

55

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART



RELEASED
98.05.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
DATE		D2199	SHEET 1 OF 1
98.04.28		TITLE	SCALE
		STRUT DETAILS	NTS

A	1993	NEW ISSUE
B		ADDED -11, -13, AND -15
C		ADDED -17 AND -19
D		ADDED -21
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD
E1	98.05.22	ADD FINISH

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

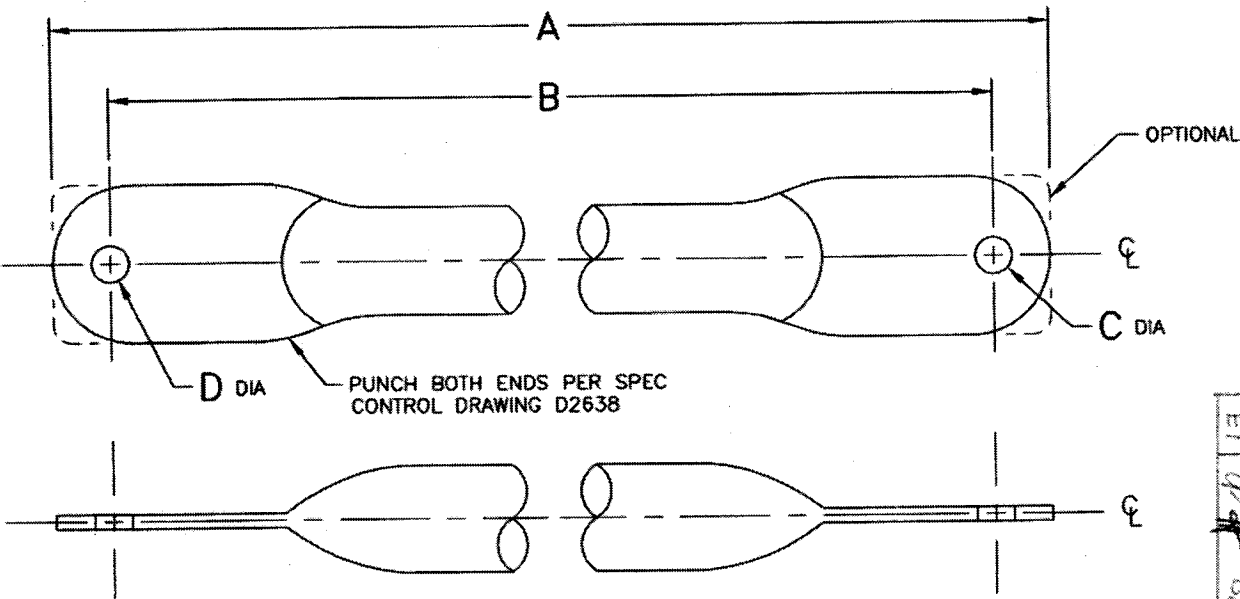
WORK ORDER

NO. 46229

110-075

BBBDDDEE

#00.10.13
(P.00.10.13)



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 05 43/EN

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